

Push

Ship Friday

Work Order ID 144182

144182

Wednesday, April 06, 2016 10:16:17 AM

Page 1

Item ID: D5235-042

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: RH Step Assembly

Stop ***NS2***

Start Date: 4/6/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/8/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: *

Process Plan: *mf*

Date: *16-4-6*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5235	B								

110

0.05

110

Small Fab

Small Fab

Memo

0.00

1- ASSEMBLE FIXTURE DT10150 WITH BLOC "A", "B" AND "C" TO
MANUFACTURE D5235-042.

2- ASSEMBLE D5273-041 FITTINGS TO D5274-1 STEP WITH PROSEAL
AS PER DWG
A/R PROSEAL: *134039*

3- INSERT ALL PARTS TOGETHER IN FIXTURE DT10150 AND
TRANSFER DRILL HOLES USING DT10186 FOR D5271-3/-4 AND DT
10185 FOR D5271-1 AS PER DWG AND NOTES 9,10.

4- DISASSEMBLE AND DEBURR.

5- a) USE DT10170 DRILL JIG TO DRILL NUT PLATE HOLES IN D5272-1/-
3 TUBE AS PER DWG.
b) DEBURR
c) TOUCH UP HOLES WITH ALODINE ONLY
d) INSTALL NUTPLATES IN TUBES

6- TOUCH UP HOLES WITH ALODINE ONLY ON D5271-1/-4 AND D5273-
041 FITTINGS.

7- USE DT10150 TO RE-ASSEMBLE REST OF THE PARTS TOGETHER
USING PROSEAL AS PER DWG
A/R PROSEAL: *134039*

DAS
36
7-89

2x *16/04/12*

P.T.O.

144182

Wednesday, April 06, 2016 10:16:17 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Customer:

Start Date: 4/6/2016 **Start Qty:** 2.00 ***2***

Required Date: 4/8/2016 **Req'd Qty:** 2.00 ***2***

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept
Oty

Reject
Qty

Reject Number

Insp. Stamp

QC14- Inspect Spray Paint

0.00

140

QC

Memo

0.00

Quality Control

APR 14 2016

Wing Walk as per dwg QSI005 4.4 Batch 113417 (0.00)

0.00

150

HandFinish

Memo

Hand Finishing

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

DAS
38
9-89

APR 15 2016

Work Order ID 144182

Wednesday, April 06, 2016 10:16:17 AM

144182

Page 4

Item ID: D5235-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: RH Step Assembly

Start Date: 4/6/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/8/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>Sold</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

2 16-4-15MCS APR 15 201616-4-15

Picklist Print

Wednesday, April 06, 2016 10:16:17 AM

Page 1

Work Order ID: 144182

144182

Parent Item: D5235-042

D5235-042

Parent Item Name: RH Step Assembly

Start Date: 4/6/2016

Required Date: 4/8/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 15.12.08 NEW ISSUE DD VERF:JLM
AS PER REV B 16.03.11 JLM VERIFIED BY:JFS

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CR3212-4-5 *CR3212-4-5* Cherry Rivet		Purchased	No				Each	200.0000		56			DAS 6 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST320			200					
					m134574			200					
D5271-1 *D5271-1* Forward Fitting		Manufactured	No				Each	22.0000		2			DAS 6 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST227			22					
					140320			22					
D5271-4 *D5271-4* RH Aft Fitting		Manufactured	No				Each	3.0000		2			DAS 6 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST227			3					
					140940			3					
D5272-1 *D5272-1* Fwd Tube		Manufactured	No				Each	19.0000		2			DAS 36 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					GA			18					
					140318			18					
					prelim			1					
					134701			1					

APR 07 2016

Picklist Print

Wednesday, April 06, 2016 10:16:17 AM

Page 2

Work Order ID: 144182

144182

Parent Item: D5235-042

D5235-042

Parent Item Name: RH Step Assembly

Start Date: 4/6/2016

Required Date: 4/8/2016

Start Qty: 2.00

Required Qty: 2.00

D5272-3

Manufactured No

Each

19.0000

2

DAS
36
89

D5272-3

Aft Tube

**

16/04/12

Location

Loc Qty

Loc Code

GA

18

140815

18

prelim

1

134702

1

Each

17.0000

4

**

DAS
6
89

D5273-041

Manufactured No

D5273-041

End Fitting Assembly

Location

Loc Qty

Loc Code

prelim

1

135150

1

ST227A

16

140324

16

Each

0.0000

2

**

DAS
36
89

D5274-1

Manufactured No

D5274-1

Step Extrusion

D5291-041

Manufactured No

D5291-041

Radius Block Assembly

Each

179.0000

28

**

Location

Loc Qty

Loc Code

prelim

4

135144

4

ST162

175

140319

175

DAS
6
89

APR 07 2016

Wednesday, April 06, 2016 10:16:17 AM

Shop Packet Print

Page 2

Picklist Print

Page 3

Wednesday, April 06, 2016 10:16:17 AM

Work Order ID: 144182

144182

Parent Item: D5235-042

D5235-042

Parent Item Name: RH Step Assembly

Start Date: 4/6/2016

Required Date: 4/8/2016

Start Qty: 2.00

Required Qty: 2.00

MS24694-S50

Purchased

No

Each

585.0000

24

MS24694-S50

Screw

DAS

6

~~8-89~~

Location

Loc Qty

Loc Code

over006

400

m134502

400

ST284

185

m134370

185

24

MS24694-S98

Purchased

No

Each

424.0000

28

MS24694-S98

Screw

DAS

6

~~8-89~~

Location

Loc Qty

Loc Code

over006

200

m133990

100

m134134

100

ST283

224

m133483

74

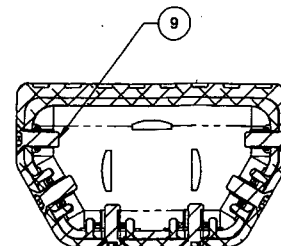
~~m134502~~

150

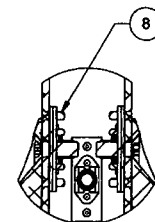
28

APR 07 2016

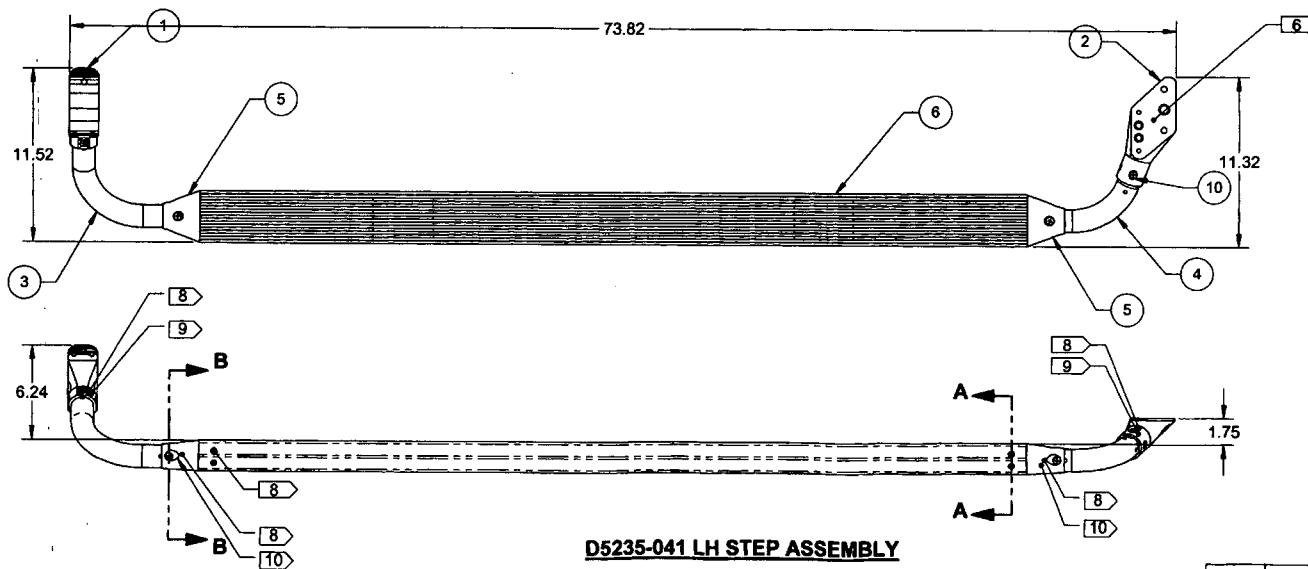
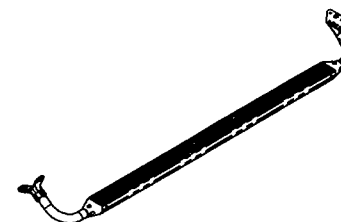
ITEM	QTY. -041	P/N	DESCRIPTION
	X	D5235-041	LH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-3	LH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	2	D5273-041	END FITTING ASSEMBLY
6	1	D5274-1	STEP EXTRUSION
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	CR3212-4-5	RIVET
9	12	MS24694-S50	SCREW
10	14	MS24694-S98	SCREW



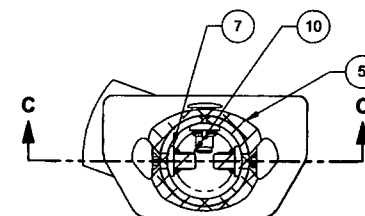
SECTION A-A



SECTION C-C



D5235-041 LH STEP ASSEMBLY



SECTION B-B

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-041" PER QSI 044 6.1
 - 7) WEIGHT: 10.47 lbs
 - 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
 - 9) TRANSFER DRILL FROM D5271-1/-3 TO D5272-1/-3
 - 10) TRANSFER DRILL FROM D5273-041 TO D5272-1/-3

RELEASED
2016-03-07
ECN 6-542

APPROVED

B	UPDATED ITEM 8, ALL SHEETS.	CC	15.12.09
A	ISSUE	CC	15.06.09
REV.	DESCRIPTION	BY	DATE
DESIGN	CC	DART AEROSPACE USA, INC EUGENE, OREGON, USA	
DRAWN	CC		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5235	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	AW139 CABIN STEP	NTS
DATE	15.12.09	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DQA: _____ Date: _____



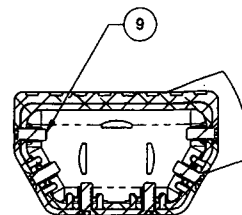
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

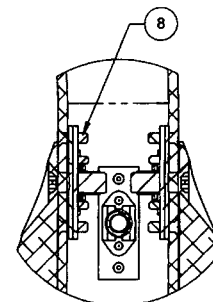
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐																																																																

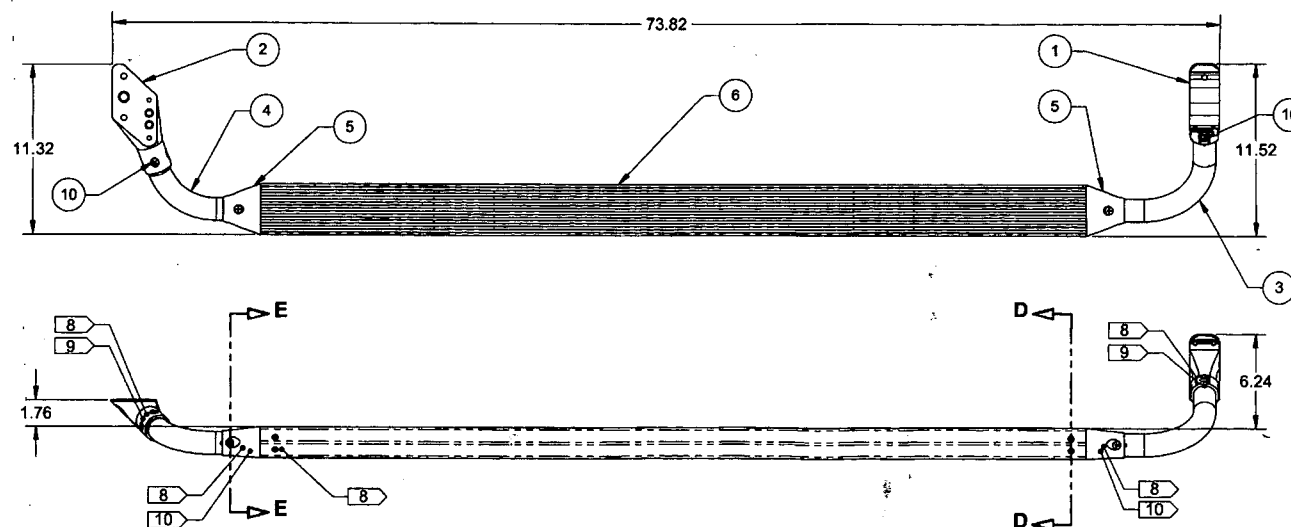
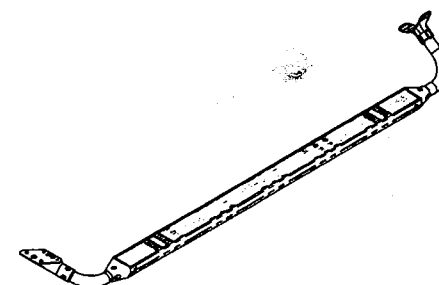
ITEM	QTY. -042	P/N	DESCRIPTION
	X	D5235-042	RH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-4	RH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	2	D5273-041	END FITTING ASSEMBLY
6	1	D5274-1	STEP EXTRUSION
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	CR3212-4-5	RIVET
9	12	MS24694-S50	SCREW
10	14	MS24694-S98	SCREW



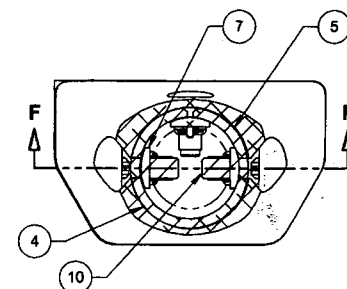
SECTION D-D



SECTION F-F



D5235-042 RH STEP ASSEMBLY



SECTION E-E

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-042" PER QSI 044 6.1
- 7) WEIGHT: 10.47 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/-4 TO D5272-1/-3
- 10) TRANSFER DRILL FROM D5273-041 TO D5272-1/-3

RELEASED
2016-03-07

APPROVED

DESIGN	CC	DART AEROSPACE USA, INC EUGENE, OREGON, USA	
DRAWN	CC		
CHECKED	VS	DRAWING NO. D5235	REV. B
MFG. APPR.	DD	SHEET 2 OF 4	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	AW139 CABIN STEP	
DATE	15.12.09	NTS	

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DQA: _____ Date: _____



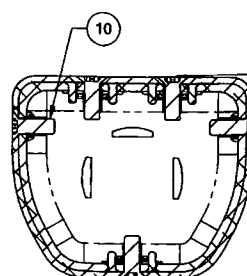
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

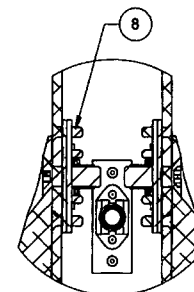
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval																	
Description Work Order Deviation		Disposition																			
				Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
<table style="width: 100%; border: none;"> <tr> <td style="width: 25%; text-align: center;">Root Cause</td> <td style="width: 25%;"></td> <td style="width: 25%; text-align: center;">FAULT CATEGORY</td> <td style="width: 25%;"></td> </tr> <tr> <td style="vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="vertical-align: top;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> <tr> <td style="vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>					Root Cause		FAULT CATEGORY		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐																		
Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																				
OTHER : ☐																					

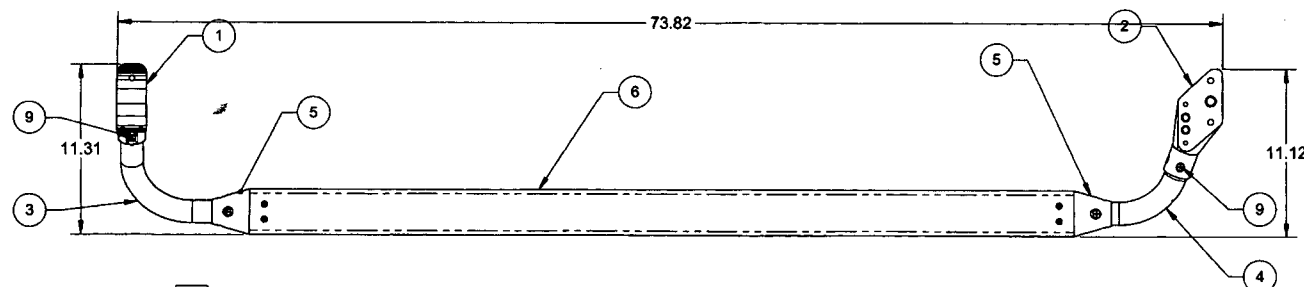
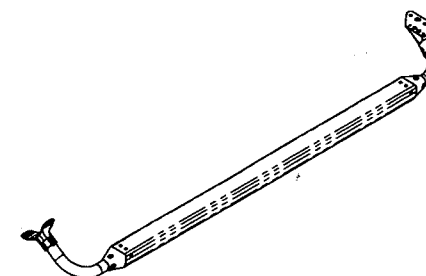
ITEM	QTY. -043	P/N	DESCRIPTION
	X	D5235-043	LH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-3	LH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	2	D5273-043	END FITTING
6	1	D5274-3	STEP EXTRUSION
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	CR3212-4-5	RIVET
9	14	MS24694-S98	SCREW
10	10	MS24694-S50	SCREW



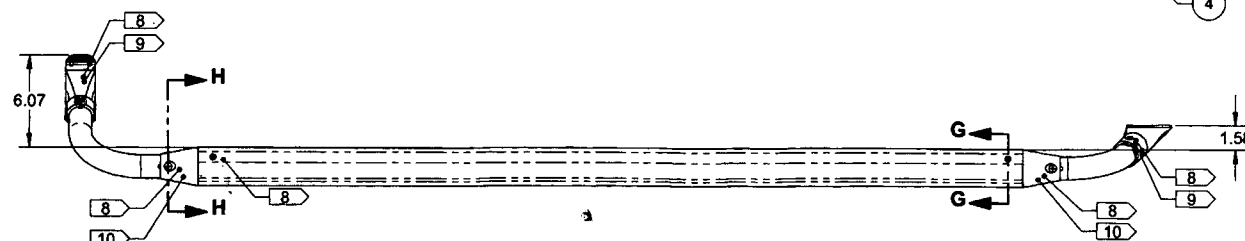
SECTION G-G



SECTION I-I



SECTION H-H



D5235-043 LH STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE OF STEP PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-043" PER QSI 044 6.1
- 7) WEIGHT: 8.65 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/-3 TO D5272-1/-3
- 10) TRANSFER DRILL FROM D5273-043 TO D5272-1/-3

RELEASED
2016-03-07

APPROVED

DESIGN	CC	DART AEROSPACE USA, INC EUGENE, OREGON, USA	
DRAWN	CC	DRAWING NO.	REV. B
CHECKED	VS	D5235	SHEET 3 OF 4
MFG. APPR.	DD	TITLE	SCALE
APPROVED	HS	AW139 CABIN STEP	NTS
DE APPR.	DS	DATE	15.12.09

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DQA: _____ Date: _____



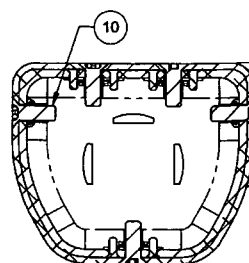
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

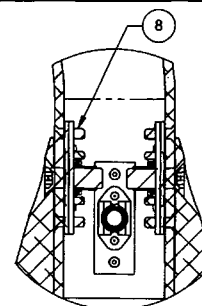
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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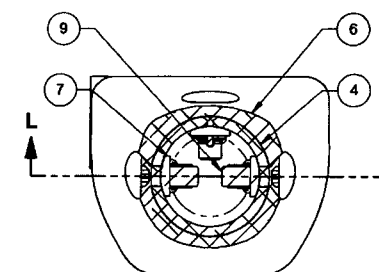
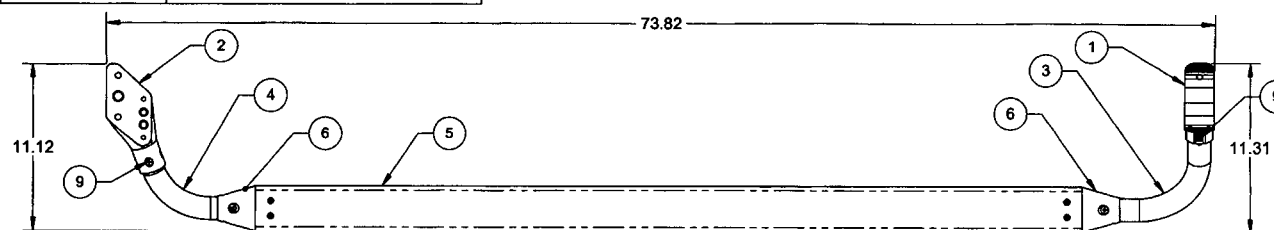
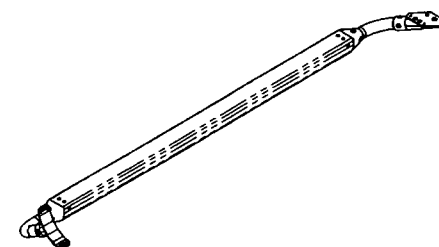
ITEM	QTY. -044	P/N	DESCRIPTION
	X	D5235-044	RH STEP ASSEMBLY
1	1	D5271-1	FORWARD FITTING
2	1	D5271-4	RH AFT FITTING
3	1	D5272-1	FORWARD TUBE
4	1	D5272-3	AFT TUBE
5	1	D5274-3	STEP EXTRUSION
6	2	D5273-043	END FITTING
7	14	D5291-041	ANCHOR NUT ASSEMBLY
8	28	CR3212-4-5	RIVET
9	14	MS24694-S98	SCREW
10	10	MS24694-S50	SCREW



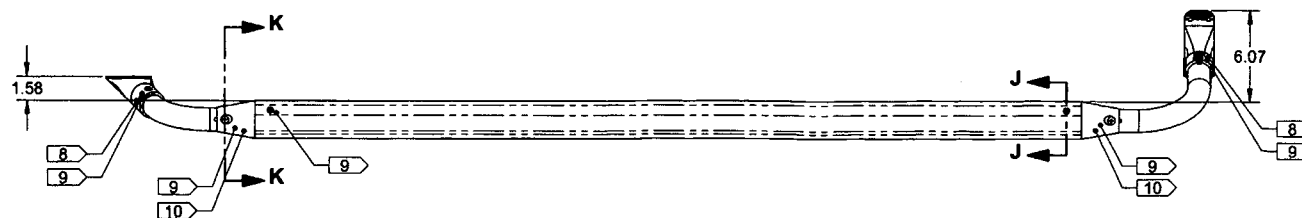
SECTION J-J



SECTION L-L



SECTION K-K



D5235-044 RH STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER DART QSI 005, SECTION 4.2, PAINT COLOUR WHITE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5235-044" PER QSI 044 6.1
- 7) WEIGHT: 8.65 lbs
- 8) ASSEMBLE WITH PROSEAL 890 USING FIXTURE DT10150
- 9) TRANSFER DRILL FROM D5271-1/-4 TO D5272-1/-3
- 10) TRANSFER DRILL FROM D5273-043 TO D5272-1/-3

RELEASED
2016-03-07

APPROVED

DESIGN	CC	DART AEROSPACE USA, INC EUGENE, OREGON, USA	
DRAWN	CC		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5235	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	AW139 CABIN STEP	NTS
DATE	15.12.09	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective : ☐		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DQA:

Date: 16.05.27



QA Closed:

Date: 16/05/17

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: 144 182		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. DS235-042		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. 16-5791		Scrap ☒		Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐	
Date: 16/04/12	Step #: 110	QTY Effective: ①				MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				DAS 9 9-89 16-05-12	
2 pms 1 DS272-1 were 1 DS272-3 Scrap because first time made + problems with the jis had to fix gis		Scrap + destroy replace DS272-1 B 140318 DS272-3 B 140815				Completed By DAS 30 9-89 APR 12 2016	
						Lead hand / Supervisor Approval Verification DAS 9 9-89 APR 12 2016	
						QC / QA Coordinator Approval DAS 9 9-89 16-05-12	
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☒		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☒	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☒	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☒	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER: positioned wrong because jis.					